

Date: Monday, 27/10/2008 7:47:08 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COLLECTIVE BELLCRANK
Job Number : 42967	
Estimate Number : 12632	
P.O. Number :	Part Number : D2127251007
This Issue : 27/10/2008 S.O. No. :	Drawing Number : D212-725-1 PG4
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 30222	Material :
Written By : <u>JP 08-10-27</u>	Due Date : 03/11/2008 Qty: 6 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-014-10 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 2X6.25X7.875

D6101-003 BILLET

Batch: # 34873

JP 08/10/27

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA656 and Dwg D212-725-1

JP 08/10/27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JP 08/10/27 (C)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

MILL SLOTS AS PER DWG D212-725-1. using DT8895.

2-Deburr & Tumble

JP 08/11/02

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JP 08/11/02 (C)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE BELLCRANK

Job Number: 42967

Part Number: D2127251007

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



(5)

P10

Comment: SECOND CHECK

JL 08/11/03

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(5)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 08/11/04

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(5x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H 08/11/04

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P 8/11/04

(5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-04

DART AEROSPACE LTD		Work Order: 42967
Description: <i>COLLECTIVE Beelcrank</i> 212-725-1-007		Part Number: D212-725-1-007
Inspection Dwg:	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.816	+/- .010	.816				
.225	+/- .010	.229				
.380	+/- .010	.380				
2.25	+/- .030	2.250				
100°	+/- 1/2°	100°				
.096	+/- .010	.096				
R.13	+/- .030	R.13				
.032 x 45°	+/- .010 +/- 1/2°	.038 x 45°				
.025 x 45°	+/- .010 +/- 1/2°	.030 x 45°				
6.462	+/- .010	6.458				
R.63	+/- .030	R.63				
2.949	+/- .010	2.949				
2.268	+/- .010	2.268				
.250 Ø	+ .006 - .001	.252				
.740	+/- .010	.740				
.853	+/- .010	.853				
.983	+/- .010	.983				
2.829	+/- .010	2.829				
1.098	+/- .010	1.098				
.808	+/- .010	.808				
R.76	+/- .030	R.760				
.906	+ 0.0 - .002	.905				
1.000	+ 0.0 - .002	.999				

Measured by: <i>KJ</i>
Date: <i>08/24/03</i>

Audited by: <i>J.L</i>
Date: <i>08/11/03</i>

Prototype Approval: <i>N/A</i>
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

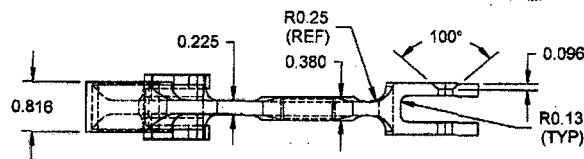
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-725-1-007 PAR #: N/A Fault Category: PROD. MACHINE NCR: Yes No DQA: NA Date: 08.11.10
Resolved: Scrap Disp: Scrap QA: N/C Closed: NA Date: 08/11/20

NCR: <u>42967</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/11/2</u>	<u>6</u>	<u>- DIMENSION .008" BORDERLINES AT .216" TO .218" SLOT OFF CENTER .0075" - RESULT OF CALCULATION ERROR.</u>	<u>CP</u> <u>08.11.03</u> <u>pu</u> <u>QSI 042</u>	<u>Critical part. No dim deviations permitted. SCRAP REF DS EMAIL</u>	<u>CP</u> <u>08/11/02</u>	<u>CP</u> <u>08.11.03</u> <u>pu</u> <u>QSI 042</u>	<u>CP</u> <u>08.11.03</u> <u>pu</u> <u>QSI 042</u>	<u>CP</u> <u>08.11.03</u> <u>pu</u> <u>QSI 042</u>

NOTE: Date & initial all entries

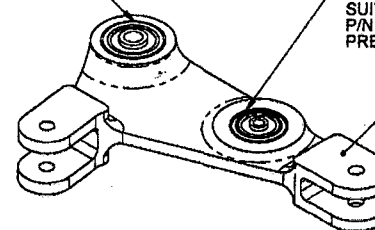
w/p 42967



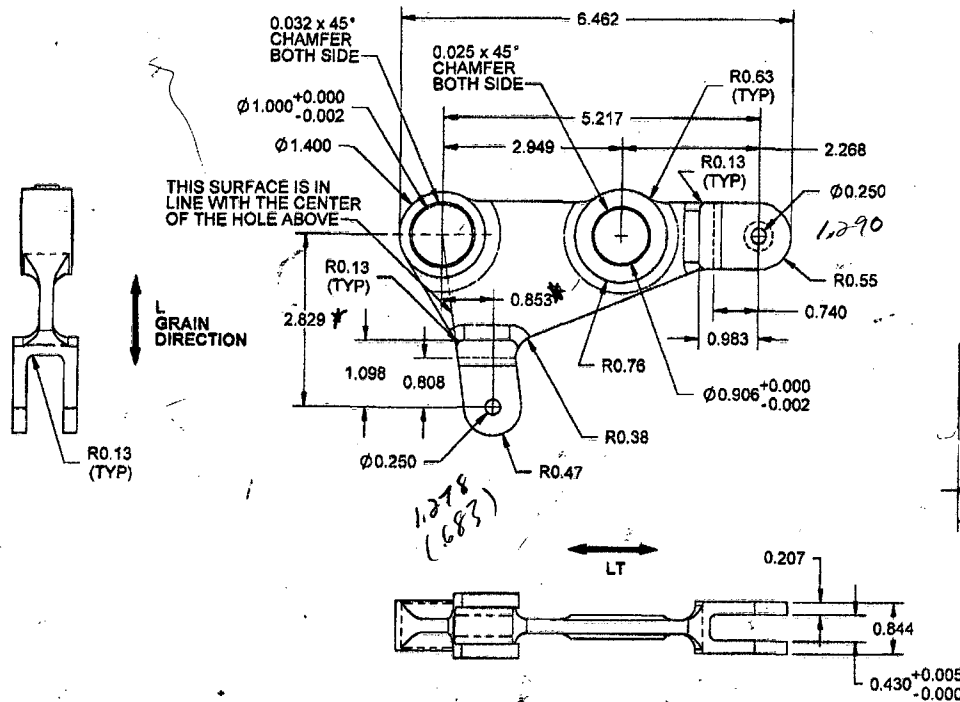
P/N 120-015-5A SLEEVE (1)
SUITED TO FIT BEARING
P/N MS27647-5 BEARING (1)
PRESS FIT

P/N 120-013-3A SLEEVE (1)
SUITED TO FIT BEARING
P/N MS27643-3 BEARING (1)
PRESS FIT

D212-725-1-007
COLLECTIVE BELLCRANK



D212-725-1-901 COLLECTIVE BELLCRANK ASS'Y



D212-725-1-007 COLLECTIVE BELLCRANK

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) LPI PER ASTM 1417 LEVEL 2
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

RELEASED
08070314

B	07.05.11	UPDATE MATERIAL & GRAIN DIRECTION	
A	06.12.08	NEW ISSUE	
DESIGN	DC	DRAWN BY	RF
CHECKED	DS	APPROVED	HA
DATE	07.05.11	DRAWING NO.	D212-725-1
		TITLE	212S DETAIL PARTS
		REV. B	SHEET 4 OF 44
		SCALE	1:2

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Handwritten calculations:
 $\frac{.203}{.905} = .224$
 $.224 \times .608 = .136$
 $.136 + .015 = .151$

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: November 3, 2008 1:58 PM
To: 'Chris Provencal'
Cc: 'Jason Murdoch'
Subject: RE: NCR D212-725-007

Part is unacceptable. Please scrap. This is a critical part.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Monday, November 03, 2008 8:23 AM
To: 'David Shepherd'
Cc: 'Jason Murdoch'
Subject: NCR D212-725-007

David,

Qty(1) D212-725-007: The slot wall is under tolerance on one side. The 0.228 dim is 0.215. The wall thickness on the other side of the slot is in tol at 0.231. Ref attached picture. I have no info on this, as it's a mysterious Eagle-S part. Is this acceptable?

-Chris

No virus found in this incoming message.

Checked by AVG.

Version: 7.5.549 / Virus Database: 270.8.5/1763 - Release Date: 11/2/2008 7:08 PM

No virus found in this outgoing message.

Checked by AVG.

Version: 7.5.549 / Virus Database: 270.8.5/1764 - Release Date: 11/3/2008 7:46 AM